

Date: Tuesday, 4/4/2006 1:27:24 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ANGLE
Job Number :	26495		
Estimate Number :	10196		
P.O. Number :	N/A	Part Number :	D21751
This Issue :	4/4/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2175 REV. D.
First Issue :	N/A	Project Number :	N/A
Previous Run :	26028	Drawing Revision :	D
		Material :	N/A
Written By :	SKG COMMENT Below	Due Date :	4/28/2006
Checked & Approved By :	KA 06.04.04	Qty:	20
Comment :	Est E 04.06.09 Reformat KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 9.9162 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063) Batch: M19039 m/ 06 05 09

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
Cut blank: 12.75" x 2.95" Grain along 2.95"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA083 and Dwg D2175
Stack of 10
Identify as D2175-1

Dwg Rev: D
Prog Rev: D

06 05 10 (20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 05 10 (20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06-05-13 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/05/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ANGLE

Job Number: 26495

Part Number: D21751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

H.M 06/05/24
SAN 06:05:15 20

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Form as per Dwg D2175

SB 06/05/23

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-25 20

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/25

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06/18/25 20
06/05/25 20

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST220

AL 06/05/25 20

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/26 20

Job Completion



U 06-05-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



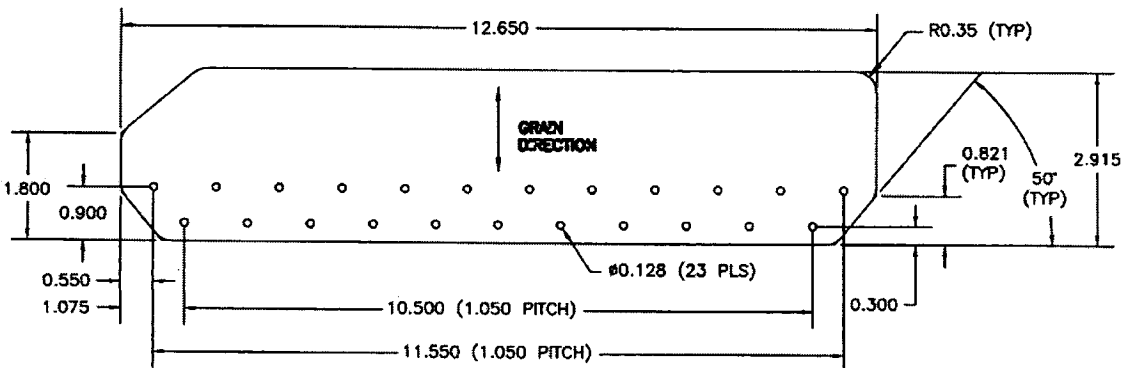
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV. D
		D2175	SHEET 1 OF 1

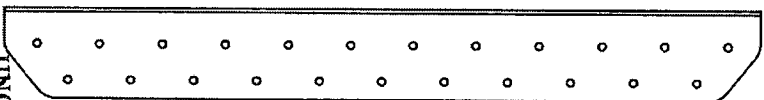
DATE	TITLE	SCALE
04.06.03	ANGLE	1:3

A	95.10.25	NEW ISSUE
B	96.01.18	CHANGED DIMENSION
C	00.09.11	UPDATE FINISH SPEC
D	04.06.03	RE-DESIGN

RELEASED
04.06.03



D2175 FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE



WORK ORDER
NO. 26495

SHOP COPY

RETURN TO

ENGINEERING

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